

DART AEROSPACE LTD		Work Order:	22250
Description: Handle Assembly		Part Number:	D3331-041
Dwg: D3331 Rev. A		Qty:	10

Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler		05.01.17	10
2	MFA MC	Cut handle to finish length as per Dwg D3331 Material: AISI 1010-1025 Ø0.875" tubing, 0.125" wall (M1025TR0.875W.125) Identify for D3331-1	EP	05/02/15	10
3	MFA MC	Form as per Dwg D3331 using DT8760 crimping Jig	CPL	05-02-15	10
4	MC	Turn as per Folio FA491 and Dwg D3331	EP	05/02/15	10
5	QC2	Inspect parts as they come off the CNC machine Identify as D3331-1	EP	05/02/15	10
6	QC8	Second check		05-02-15	10
7	MC	Deburr	EP	05/02/15	10
8	MFA	Drill dowel hole as per Dwg D3331	CPL	05-02-16	10
9	MFA	Insert and Weld dowel as per Dwg D3331 Pick: Qty Part Number Description Batch			
		1 3/16"-1" long Dowel M16054			
		A/R N/A Steel Rod B93216	CPL	05-02-16	10
10	QC5	Inspect work to Step 9	M	05-02-17	10
11	FP	Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3	M	05-02-17	10
12	QC3	Inspect Powder Coat	W	05-02-17	10
14	MFA	Assemble as per Dwg D3331 Pick: Qty Part Number Description Batch			
		1 GP-78R Black Vinyl Grid M16038			
		Identify as D3331-041	CPL	05-02-18	10
15	QC5	Inspect work to Step 14	RF	05-02-18	10
16	ST	Identify and Stock	CPL	05-02-18	10
17	AC	Cost / part: <u>25.29</u>	SAC	05-02-21	10
18	DC	Close W/O <u>25.29</u> Inspect Level 21	OFF	05-02-23	10

Rev	Date	Change	Revised By	Approved
A	05.01.13	New issue	KJ/JLM	

RELEASED  
05-01-17

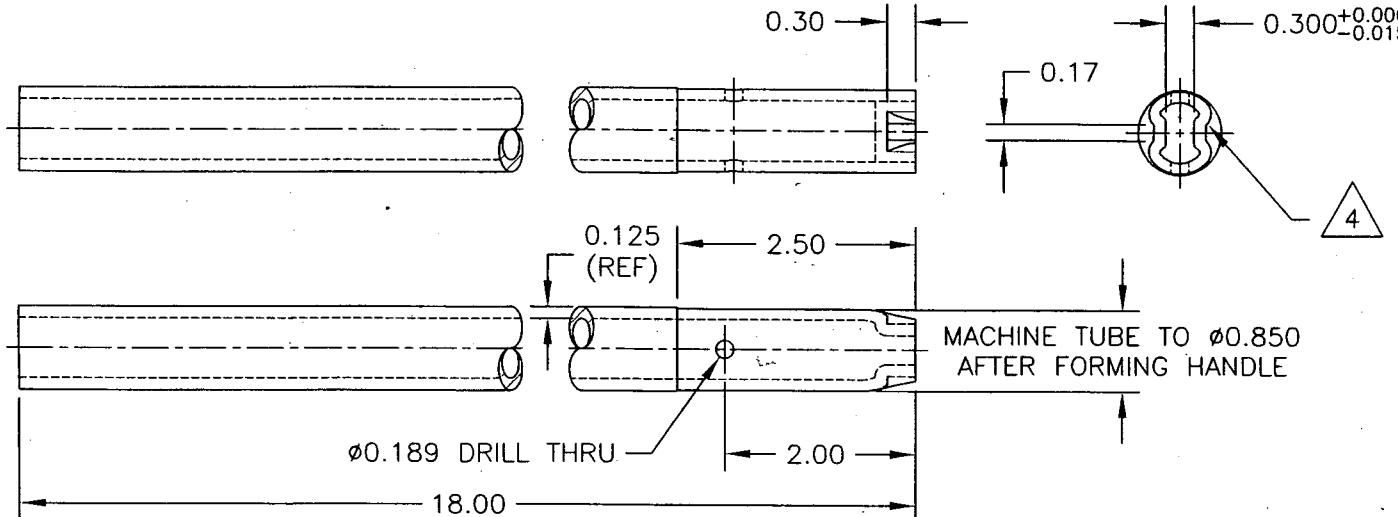
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector		
			Initial Design Mgr	Action Description Design Mgr	Sign & Date					

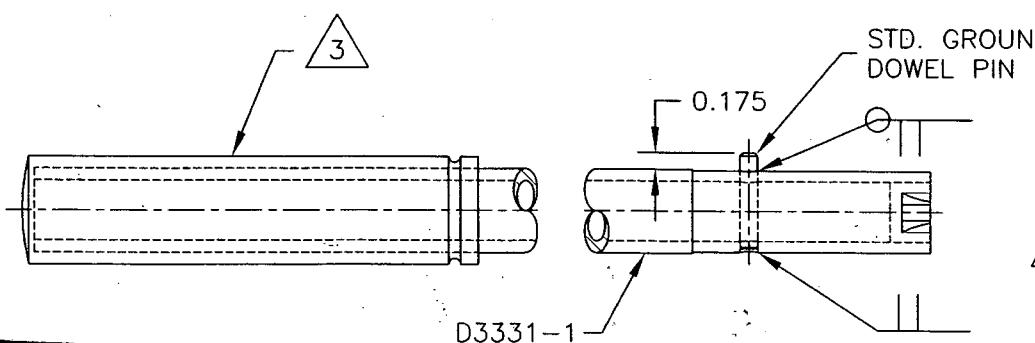
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

# PRELIMINARY ISSUE



1 D3331-1 HANDLE

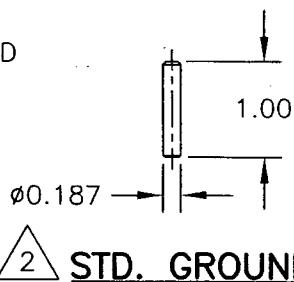


2 D3331-041 HANDLE ASS'Y

NOTES:

- 1) MATERIAL: 1025 ROUND BAR STEEL PER MILL-S-7097  
(REF. DART SPEC. M1025TR0.875W.125)
- 2) STD. GROUND DOWEL PIN, Ø3/16" x 1.00" LONG  
POSSIBLE SUPPLIER: SPAENAUR, P/N 238-032
- 3) STD. BLACK VINYL GRIP, 7/8" I.D. x 4 3/4" LONG  
POSSIBLE SUPPLIER: REID TOOL SUPPLY CO., P/N GP-78R
- 4) FORM USING TOOLING DT8760
- 5) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES
- 8) BREAK ALL SHARP EDGES 0.005 TO 0.010

UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 22250



SHOP COPY

RETURN TO

ENGINEERING

DESIGN <i>13</i>	DRAWN BY <i>AB</i>	DART AEROSPACE LTD	
CHECKED <i>RF</i>	APPROVED	HAWKESBURY, ONTARIO, CANADA	
DATE 04.11.29	DRAWING NO. D3331	REV. A	
A	04.11.29	TITLE HANDLE WELDMENT	SHEET 1 OF 1
		SCALE 1:2	

## Job Costing Report

Dart Aerospace Ltd.  
HawkesburyJan 17, 2005  
01:31 pm

Work Order No : 0022250  
 Project Name : D3331-041  
 Project For :  
 Work Order Type : Main  
 Main WO Number :  
 House Part Number : D3331-041  
 Description : Handle Assembly  
 Manufactured : Yes  
 Amount Req'd : 10  
 Amount Done : 0  
 Start Date : 01-17-05  
 Est Finish Date :  
 Act Finish Date :  
 Drawings Reqd : No  
 Ok for Approval :  
 Approval Rec'd :

Department Code:  
 Burden Flags : NNNNNNN  
 WO Status : Open  
 Invoice State : Not Invoiced  
 Invoice Date :  
 Invoice Number :  
 Invoice Amount : 0.00  
 Order Entry No :  
 OE Value : 0.00  
 Est Margin : 0.000%  
 Actual Margin : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/ (Loss)	0.00	0.00

DART AEROSPACE LTD	Work Order:	22250
Description: HANDLE WEDIMENT	Part Number:	D333/100-1
Inspection Dwg:	Rev:	Page 1 of 1

## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

Measured by:	En	Audited by:	<i>Jud</i>	Prototype Approval:	N/A
Date:	05/02/15	Date:	05-02-15	Date:	

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	